

Date: Thursday, 2/8/2007 12:05:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 3" SKID EXTRUSION (NO OUTER RIDGE)	
Job Number	: 30682		Part Number	: D26003120	
Estimate Number	: 10054		Drawing Number	: D2600 REV D1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/8/2007	S.O. No. : N/A	Drawing Revision	: D1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/28/2007	
Previous Run	: 26205		Qty:	80	
Written By	: <u> </u>		Um:	140	
Checked & Approved By	: <u> </u> 07.02.08		Each		
Comment	: Est. D. 02.09.10 Added DSK 066 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>3090</u> <u>C207/02/09</u>  a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		
2.0	D26003120P	Extrusion Round 3" 350
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s) Extrusion Round 3" 350		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:05:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 30682

Part Number: D26003120

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Back Hall

JB 7-2-28

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7-07-03/01

Job Completion



7-07-02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS + DIE NUMBERS	<i>+ GP</i>

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

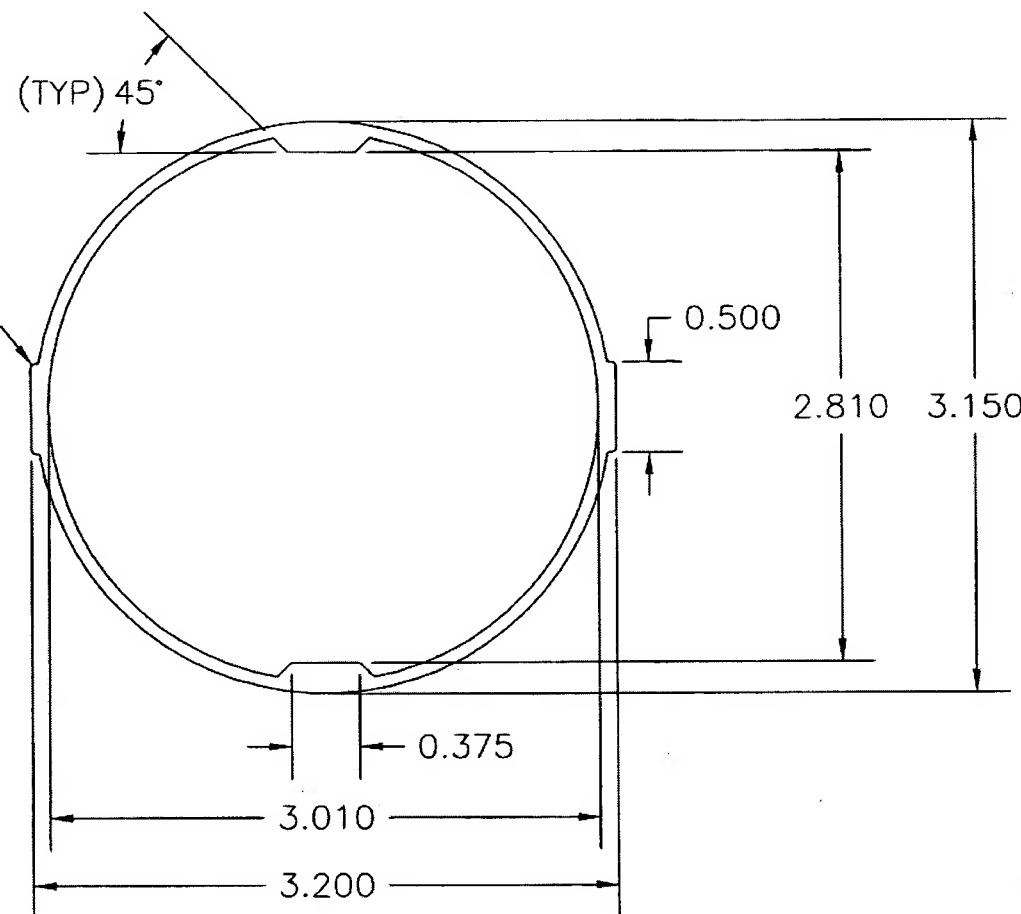
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER
NO. 30682

DART

DESIGN <i>mg</i>	DRAWN BY <i>mg</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JP</i>	DRAWING NO. D2600
DATE 98.08.20	TITLE EXTRUSION	REV. D SHEET 2 OF 5 SCALE 1:1

RELEASED
98/825 DSD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

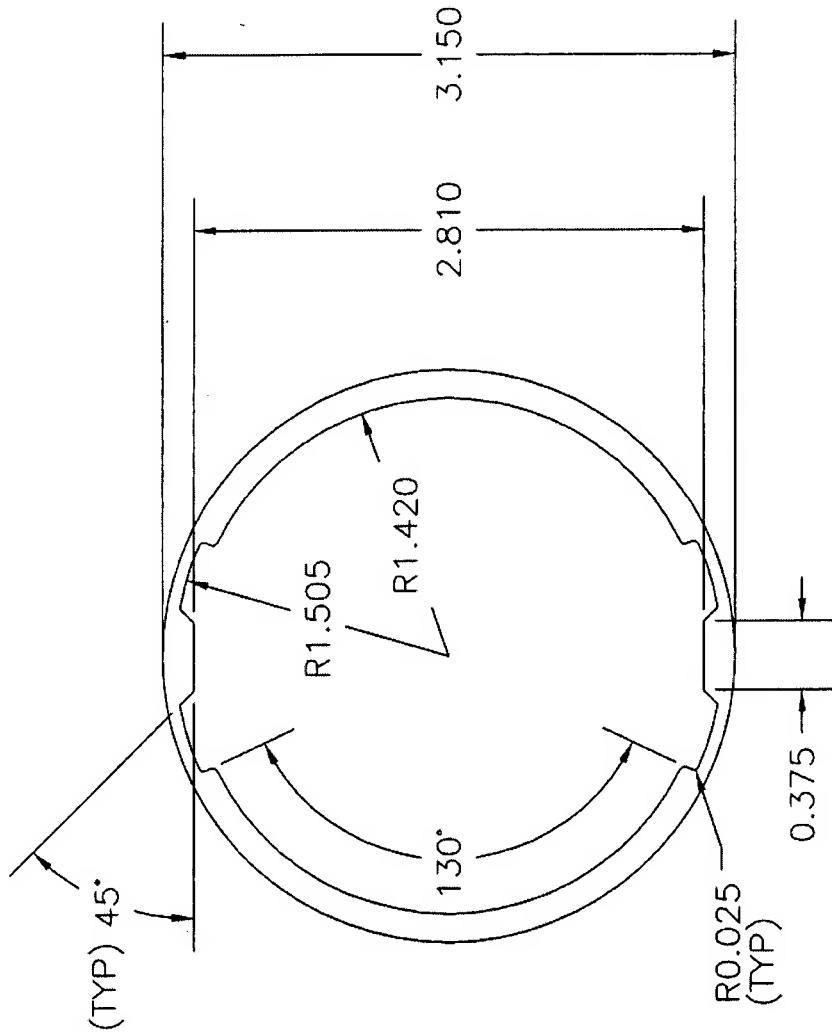


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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2600	SHEET 3 OF 5
98.08.20		TITLE	SCALE
		EXTRUSION	1:1

RELEASED
98.8.25 DS

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120" LONG)

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NO. 30682

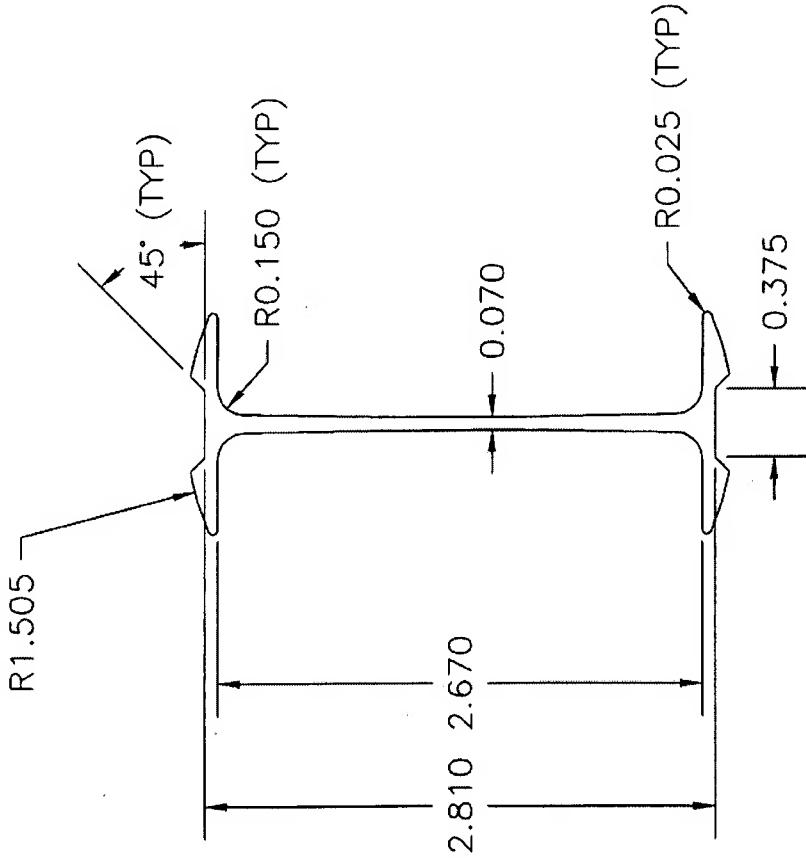
 **D1**



1 COPY IS
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DESIGN <i>MB</i>	DRAWN BY <i>BB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CF</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART Number IS D2600-5-XXX WHERE XXX IS Cut LENGTH IN INCHES
(EG. D2600-5-108 IS 108" Long)



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WITHOUT NOTICE

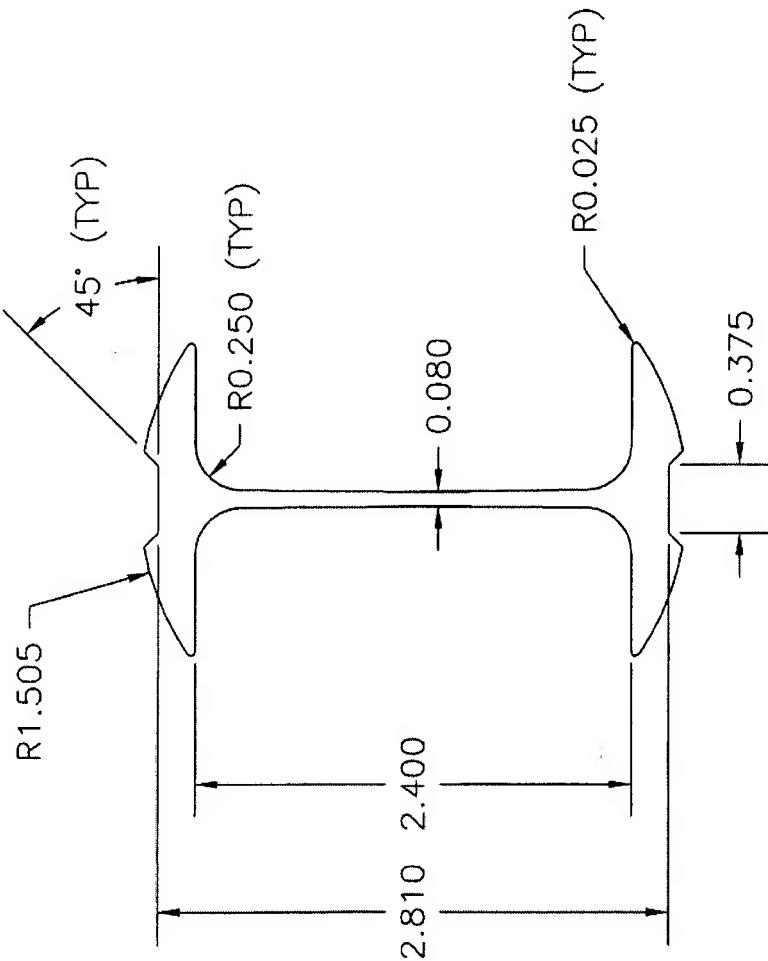
WORK ORDER

NO. 30682

DART

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CHECKED	APPROVED	DRAWING NO.	REV. D
KE	AS	D2600	SHEET 5 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1

RELEASED
98.8.25 DS

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" Long)

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NO. 30682



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Printed Date	Serial No.	Printed Date	Page
02/19/07	155268	58533	1
00003090	00335009	58533010	2/19/07

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cost Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Cross Weight	1257 LBS		
Net Wt.	1,217 LB	78 PC	780 FT
Specification			Spec Desc
AMS-QQ-A-200/8 & ASTM B221-00			

Mechanical Tests:

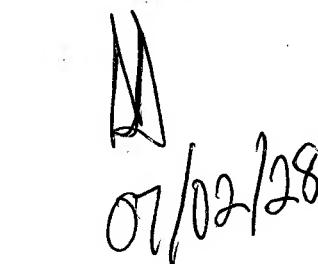
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	322.8 / 46.9	304.5 / 44.2	12.3	.0	97	

Chemical Limits:

SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.40	.00	.15	.00	.80	.04	.00	.00 EA: .05
MAX:	.80	.70	.40	.15	1.20	.35	.25	.15 TOT: .15

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada


07/02/07

